

Work Order ID 61044

August 4, 2010 2:33:04 PM

Page 1

Item ID: D206-642-441

Accept

Setup Start

Revision ID:

Stop

Item Name: Replacement Skidtube

Start Date: 8/04/10 Start Qty: 1.00

Cust Item ID:

Required Date: 8/16/10 Req'd Qty: 1.00

Customer:

Reference:

Approvals:

Process Plan:

Date: 10-8-04

Tooling:

Date:

QC:

Date:

SPC (Y/N):

Date:

Run Start

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

Draw Nbr

Revision Nbr

D2650

Rev F

100

0.00

DC

0.00

Document Control

Memo

Photocopy bluefile and create labels per PPP D206-642-441 CHG002

N/A

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
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Run Start



Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
110	Skidtubes	0.00							
Skidtubes	Memo	0.00							
Skidtubes	1-Deburr Fwd edge of tube								
	2-Remove ridge on inside of Fwd edge of tube as per Dwg D2650								
	3-Weld Fwd Cap as per Dwg D2650. Use aluminum rod. Grind D2647 to fit as required. A/R <input type="checkbox"/> Aluminum Rod <input checked="" type="checkbox"/> <u>M112507/M114242</u>								
	4-Grind weld flush to cap on top surface only.								
	5-Cut aft end 138.60" from front of tube								
	6-Drill pilot holes using drill jig DT8025 & DT8169 (A,B,C,D). Open to Ø0.312".								
	7-Drill holes for wearplates using DT 8028-7. Open to Ø 0.297".								
	8-Open using #6 Drill Bit								
	9-Open holes for Tow Ring to Ø0.625" as per Dwg D2650, D2650-7 Drilling Detail								
	10-Remove inner indexing ridge on aft end of skidtubes as per Dwg D2650.								
	11-Deburr and Blow out all chips from inside the tube								

DP 10-8-10

BE 10-8-10

DP 10-8-11

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Run Start



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
115 QC Quality Control	QC5- Inspect part completeness to step on W/O Memo	0.00 0.00		81010814					
116 QC Quality Control	QC10- Inspect visual per QSI004- ground welds Memo	0.00 0.00		81010814		(X)			
120 HandFinish Hand Finishing	Chemical Conversion Coat per QSI005 4.1 Memo	0.00 0.00		DP 10-8-11					

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QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130 	QC3- Inspect Part Finish	0.00							
QC Quality Control	Memo	0.00							

(1X)

Q MB 10-08-12

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

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Run Start



Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

140

0.00



Skidtubes

Skidtubes

0.00

Memo1-Open holes to finished size as per Dwg D2650, D2650-7 Drilling Detail
(without cutting fluid)

2-Countersink crossbolt spacer holes as per Dwg D2650(without cutting fluid)

3-Deburr. Blow out chips. Grind alodine off around crossbolt spacer.

4-Bond D2654-7 web in place as per QSI 015Ensure holes line upAllow 12 Hrs.
cure time before cutting☐

Start Date: 10-8-12

Time: 11:00AM

☐

Finish Date: 10/8/12

Time: 7:35AM

A/R ☐ Sikaflex-291 ☐ M115114 ☐

Sikaflex expiry date: 11-3-30

W/O:		WORK ORDER CHANGES					
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Customer:

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Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

150

QC5- Inspect part completeness to step on W/O

0.00



QC

Memo

0.00

8/10/08/16

(+)

Quality Control

160

Skidtubes

0.00



Skidtubes

Memo

0.00

1-Prep per QSI 005 and Insert cross bolt spacers D2649. Weld as per QSI 004 and Dwg D2650. Remember to back drill each hole to 0.25" before welding the other side. Use aluminum rod.

A/R Aluminum Rod M112507

BE 10/05/16

2-Grind welds flush as per Dwg D2650.

3-Counterbore 5/16" x 0.750" deep as per Dwg D2650 Debur

DP

10-8-17

W/O:		WORK ORDER CHANGES					
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Customer:

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Run Start



Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Stop



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

170

0.00



HandFinishing

Skidtubes

Memo

0.00

Skidtubes

Install D2680-041 Nut Plate as per Dwg D2650

DP 10-8-17

180

0.00



QC10- Inspect visual per QSI004- ground welds

QC

Memo

0.00

Quality Control

8/10/06/12

190

0.00



QC5- Inspect part completeness to step on W/O

QC

Memo

0.00

Quality Control

8/10/06/12

QC

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Run Start



Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Stop



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
200 HandFinish Hand Finishing	Pressure Wash per QSI005 4.3 Memo Brush alodine tube on crossbolt spacer area, do not acid etch, do not dip tube in tank.	0.00 0.00				1	0		
205 SprayPaint Spray Painting	Memo Spray paint Delfleet Blue Primer B 114424 Delfleet Blue B 113171 Clear delfleet B 115506	0.00 0.00				ml	10	09	02 (1)
206 QC Quality Control	QC14- Inspect Spray Paint Memo	0.00 0.00				AS	10	09	03 (x1)

W/O:		WORK ORDER CHANGES					
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Customer:

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QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Run Start



Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

230

0.00



Hand Finish

HandFinishing

Hand Finishing

Memo

0.00

⇒ Jb

10/09/07

1

6

1-Install inserts & wearpads as per dwg D2922. Use a drop of Sikaflex inside insert holes before installing wearpad/wearplate.

A/R ☐ Sikaflex-291 ☒ 114093 ☐Sikaflex expiry date: ☐ 10/10

2-Install O-Rings D2651-3 on plugs D2651-1 with Petroleum Jelly and install plugs as per Dwg D2650. Clean excess adhesive

3-Install MS27039-4-06 Screw as per DEO 9153

4-Inspect for foreign object per QSI 024

5-Install D2646 Aft Cap and seal with SikaflexClean excess adhesive

A/R ☐ Sikaflex-291 ☒ 114093 ☐Sikaflex expiry date: ☐ 10/10

6-Wing Walk as per Dwg D2650-7 and QSI 005 4.4

Batch: 115 025

W/O:		WORK ORDER CHANGES					
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Run Start



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

240

QC5- Inspect part completeness to step on W/O

0.00

5/10/09/07



QC

Memo

0.00

②

Quality Control

250

Packaging

0.00



Packaging

Memo

0.00

Identify and pack for shipping as per PPP D206-642-441

Location: _____

PPP Rev: _____

PPP 61004

10/9/08 ②

260

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

10/09/09 ②

Quality Control

BS 10-9-08 ②

W/O:		WORK ORDER CHANGES					
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Picklist Print

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Page 1

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Parent Item Name: Replacement Skidtube

Start Date: 8/04/10

Required Date: 8/16/10

Start Qty: 1.00

Required Qty: 1.00

Comments: IPP Rev:H 05.10.11 Added D3429-1 per CHG002 KJ/CP/JLM
IPP Rev:I 08-05-01 add QC3 DD verified by:EC
IPP Rev:J 08-09-29 revF as per dwg DD verified by:

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
---------------------------------	------------------------	---------------	-------------	---------------------	------------------	-----------------	--------------------	----------------	-------------	--------------	---------------	----------------	--------

D2620
Skidtube, 206 Skidtube

Manufactured No

110

Each

8.0000

1

1

Location

Loc Qty

Loc Code

LG

57542

110

Each

79.0000

1

1

D2646
Aft Cap

Manufactured No

110

Each

79.0000

1

1

Location

Loc Qty

Loc Code

FP-4

70

57332

70

FP6

9

52663

9

D2647
Cap

Manufactured No

140

Each

76.0000

1

1

Location

Loc Qty

Loc Code

FP

76

55352

76

D2654-7
Web

Manufactured No

160

Each

0.0000

1

1

B61264

①

DP 10-8-12

W/O:		WORK ORDER CHANGES					
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Start Date: 8/04/10

Required Date: 8/16/10

Start Qty: 1.00

Required Qty: 1.00

CCR264SS3-3

Purchased

No

170

Each

532.0000

2

2



Cherry Rivet

Location

Loc Qty

Loc Code

ST311

532

112314

4

113539

60

143973

468

170

Each

140.0000

23

23



D2649

Manufactured

No



Cross Bolt Spacer

Location

Loc Qty

Loc Code

LG

140

58545

12

60652

128

170

Each

39.0000

1

1



D2680-041

Manufactured

No



Nut Plate

Location

Loc Qty

Loc Code

ST021

39

55366

39



10-8-17

W/O:		WORK ORDER CHANGES					
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Start Date: 8/04/10

Required Date: 8/16/10

Start Qty: 1.00

Required Qty: 1.00

ALS4-1032-130 Purchased No

230 Each

3,842.000 60 60



10/09/07

Insert

Location

Loc Qty

Loc Code

PKG11

3602

114723

3602

x60

ST282

201

110511

38

114407

163

ST381

39

114654

39

AN960JD10L NAS1149D0332J Purchased No

230 Each

2,635.000 62 62



10/09/07

Washer

Location

Loc Qty

Loc Code

ST348

2635

110985

2635

x62

AN960JD416 NAS1149D0463J Purchased No

230 Each

0.0000 1 1



10/09/07

Washer

CR3212-4-03 Purchased No

230 Each

1,926.000 2 2



Cherry Rivet

Location

Loc Qty

Loc Code

ST311

1926

111359

5

112314

2

114436

448

114450

89

114859

1382

2

10-8-17

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Start Date: 8/04/10

Required Date: 8/16/10

Start Qty: 1.00

Required Qty: 1.00

D2651-1

Manufactured No

230 Each

748.0000

22 22



YJ 10/09/07

Plug

Location

Loc Qty

Loc Code

FP 152
51530 152
fpa 596
53349 411
57869 185

X22

D2651-3

Manufactured No

230 Each

356.0000

22 22



YJ 10/09/07

O-Ring

Location

Loc Qty

Loc Code

FP 356
46114 356

X22

D3535-15

Manufactured No

230 Each

10.0000

1 1



YJ 10/09/07

Wearshoe

Location

Loc Qty

Loc Code

FP18 10
59236 10

X1

D3535-23

Manufactured No

230 Each

1.0000

1 1



YJ 10/09/07

Wearshoe

Location

Loc Qty

Loc Code

FP21 1
57730 1

X1

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Shop Packet Print

Page 4

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
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Required Date: 8/16/10

Start Qty: 1.00

Required Qty: 1.00

D3535-37
Wearshoe

Manufactured No

230

Each

17.0000

1

1

Location

Loc Qty

Loc Code

FP

17

51654

4

56101

13

D3536-15
Gasket

Manufactured No

230

Each

25.0000

1

1

Location

Loc Qty

Loc Code

FP

18

56055

6

60875

12

FP11

7

59238

7

D3536-23
Gasket

Manufactured No

230

Each

14.0000

1

1

Location

Loc Qty

Loc Code

FP011

14

58819

2

60234

12

D3536-37
Gasket

Manufactured No

230

Each

15.0000

1

1

Location

Loc Qty

Loc Code

FP

15

56102

15

B351641 X

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Page 5

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W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

Page 6

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Work Order ID: 61044

Parent Item: D206-642-441

Parent Item Name: Replacement Skidtube

Start Date: 8/04/10

Required Date: 8/16/10

Start Qty: 1.00

Required Qty: 1.00

D3537-1
Wearpad
Manufactured No

230 Each 7.0000 6 6

Location	Loc Qty	Loc Code
FP	1	B61201
55465	1	
FP17	6	
57713	3	
59593	3	

10/09/07

x6

D3537-3
Wearpad
Manufactured No

230 Each 16.0000 1 1

Location	Loc Qty	Loc Code
FP19	16	
59711	16	

10/09/07

x1

MS27039-1-08
Screw
Purchased No

230 Each 1,763.000 2 2

Location	Loc Qty	Loc Code
ST291	1763	
10835	563	
114718	200	
115108	1000	

10/09/07

v2

MS27039-4-06
Screw
Purchased No

230 Each 25.0000 1 1

Location	Loc Qty	Loc Code
ST292	25	
109061	25	

10/09/07

x1

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Picklist Print

Page 7

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Work Order ID: 61044



Parent Item: D206-642-441



Parent Item Name: Replacement Skidtube

Start Date: 8/04/10

Required Date: 8/16/10

Start Qty: 1.00

Required Qty: 1.00

MS27039C1-08

Purchased

No

230

Each

1,058.000

60

60



10/09/07

SCREW

Location

Loc Qty

Loc Code

FP

1000

115336

1000

ST293

58

19185

58

X60

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NOTE: Date & initial all entries

QTY -1	QTY -3	QTY -5	QTY -7	PART NUMBER	DESCRIPTION
X				D2650-1	SKIDTUBE ASSEMBLY
	X			D2650-3	SKIDTUBE ASSEMBLY
		X		D2650-5	SKIDTUBE ASSEMBLY
			X	D2650-7	SKIDTUBE ASSEMBLY
1	1	1	1	D2600-1-160	EXTRUSION
1				D2654-1	WEB
	1			D2654-3	WEB
		1		D2654-5	WEB
			1	D2654-7	WEB
1	1	1	1	D2646	AFT CAP
1	1	1	1	D2647	CAP
17	18	19	23	D2649	CROSS BOLT SPACER
16	18	14	22	D2651-1	PLUG
16	18	14	22	D2651-3	O-RING
1	1	1	1	D2680-041	NUT PLATE
2	2			D3286-1	DOUBLER
2	2			D3286-3	STUD
42	44	54	60	ALS7-1032-130	INSERT (or AKS4-1032-130, ALS4-1032-130, ALS7-1032-130)
2	2	2	2	AN960JD10L	WASHER
2	2	2	2	CCR264SS3-3	RIVET
2	2	2	2	CR3212-4-03	RIVET
2	2	2	2	MS27039-1-08	SCREW
1	1	1	1	MS27039-4-06	SCREW
1	1	1	1	AN960JD416	WASHER
52	52			CR3212-4-04	RIVET

F

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 01044
BP10-8-04

RELEASED
08-07-23-17

NOTES:

- 1) MATERIAL: N/A
- 2) FINISH: -CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
-POWDER COAT WHITE (4.3.5.1) PER DART QSI 005 4.3
-BLACK ANTI-SKID PAINT AS INDICATED TO 0.5 ABOVE LOCATION RIDGE PER DART QSI 005 4.4
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: NONE
- 7) WEIGHT: N/A
- 8) WELD PER DART QSI 004
- 9) DAMAGE TOLERANCE ON FWD BEND:
THERE SHOULD BE NO VISIBLE WRINKLES IN THE BEND FROM THE GROUND TO A HEIGHT OF 5 INCHES ABOVE THE GROUND. IT IS ACCEPTABLE TO POLISH OUT GOUGES UP TO 0.020 DEEP IN THE BENT PORTION OF THE TUBE. A MAXIMUM REDUCTION IN DIAMETER OF 0.150" IS ACCEPTABLE IN THE BENT PORTION OF THE TUBE.
- 10) BOND WEB INTO OUTER TUBE WITH SIKAFLEX-241-291 ADHESIVE PER DART QSI 015
- 11) INSERT D2651-1 PLUG C/W D2651-3 O-RING IN HOLES MARKED 'P' (BOTH SIDES OF TUBE)
- 12) DRILL Ø0.297 FOR ALS7-1032-130 INSERTS USING TEMPLATE DT8056-1 ON -1 TUBE, DT8056-3 ON -3 TUBE, DT8056-5 ON -5 TUBE, AND DT8056-7 ON -7 TUBE. INSTALL INSERTS AFTER FINISH.
- 13) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

F	DRAWING UPDATED TO CURRENT STANDARDS. SHT 6 ADDED. ALL SECTION AND DETAIL VIEWS TRANSFERRED TO SHT 6. SHT 1 IN PL PART D2649 QTY UPDATED. SHT 6 SECT C-C GRIND INSTRUCTIONS DELETED FROM NOTE 7 (SEE NCR 239).	AJS	08.08.08
E	REMOVE CBORE, CHG DRILL, ADD CHAMFER	CP	06.03.30
D	REDRAW; INCCRP. DE09136/9153/9163 MOD GROUND HANDLING ON D2650-1/-3	CP	04.05.17
C	CHANGE HOLE PATTERN AND FRONT END	DS	97.10.29
B	AS MANUFACTURED CHANGES	DS	97.06.26
A	NEW ISSUE	DS	97.03.25
REV.	DESCRIPTION	BY	DATE
DESIGN	DS	DART AEROSPACE USA, INC	
DRAWN	AJS	PORT HADLOCK, WA	
CHECKED		DRAWING NO.	REV. F
MFG. APPR.		D2650	SHEET 1 OF 6
APPROVED		TITLE	SCALE
DE APPR.		206/407 SKIDTUBE ASSEMBLIES	NTS
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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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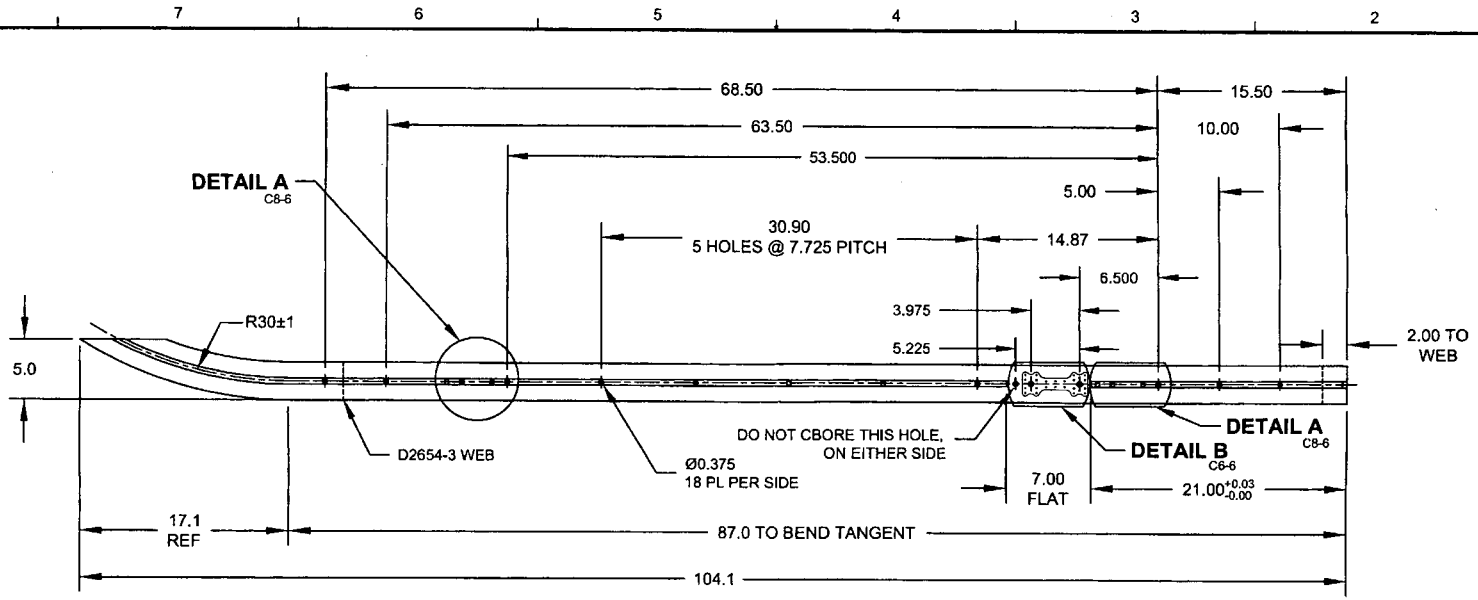
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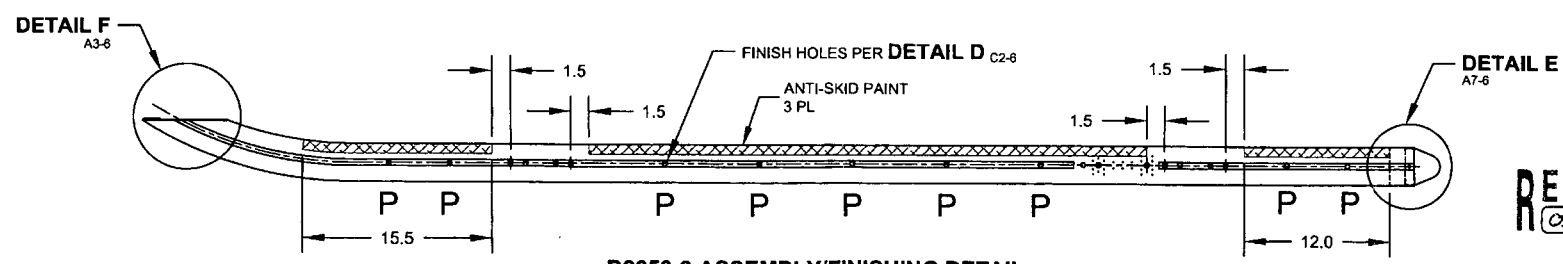
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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries



D2650-3 BENDING/DRILLING DETAIL

who 661044



D2650-3 ASSEMBLY/FINISHING DETAIL

RELEASED
08 07 22 100

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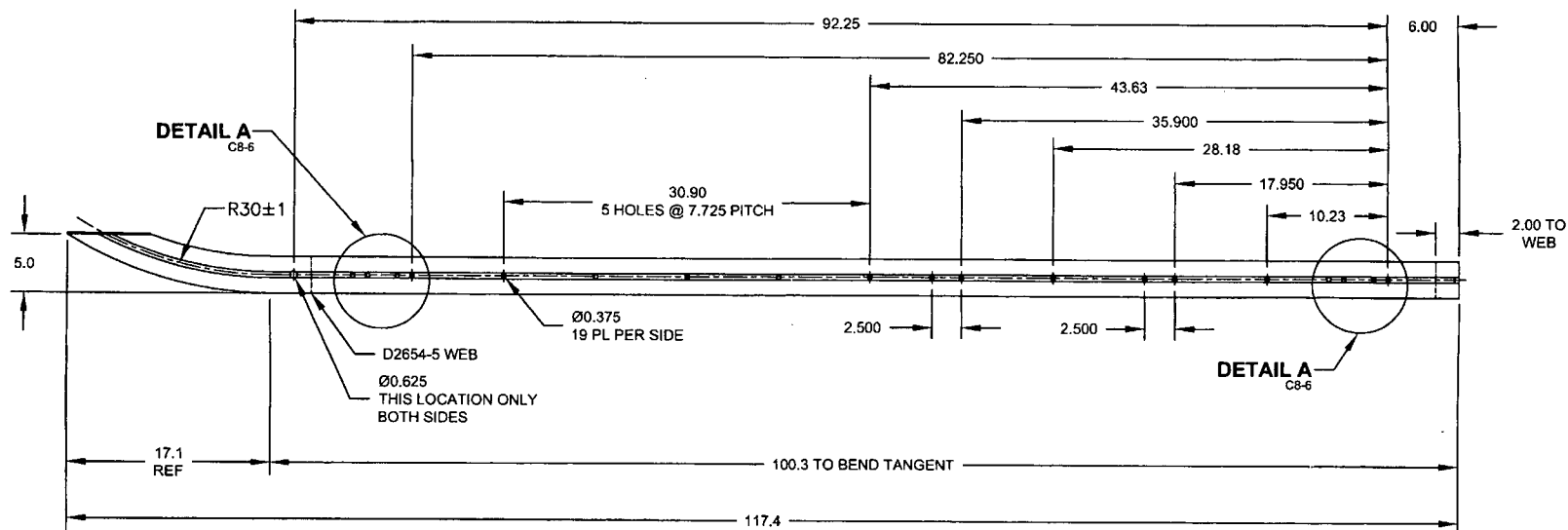
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Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

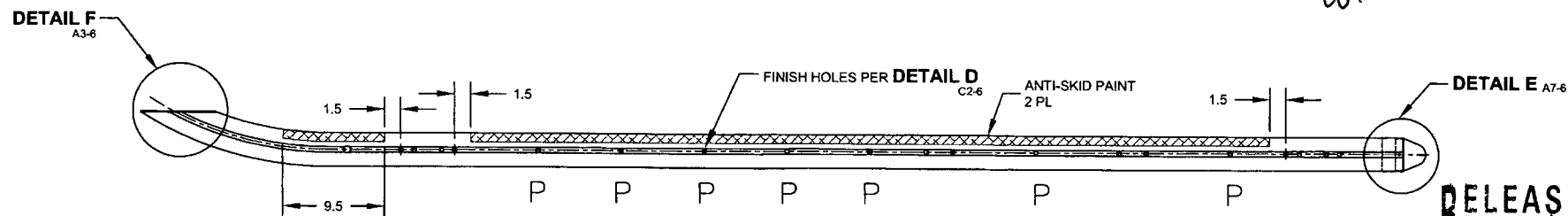
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NOTE: Date & initial all entries



D2650-5 BENDING/DRILLING DETAIL



D2650-5 ASSEMBLY/FINISHING DETAIL

DESIGN	DS	DART AEROSPACE USA, INC	
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CHECKED		DRAWING NO.	REV. F
MFG. APPR.		D2650	SHEET 4 OF 6
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W/O:		WORK ORDER CHANGES					
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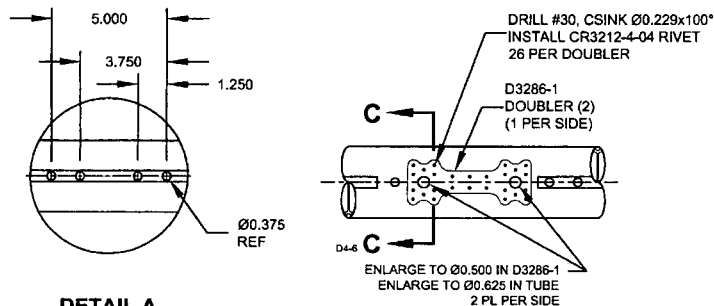
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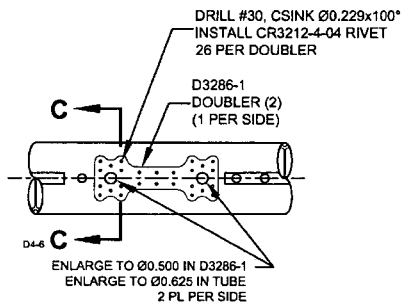
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DETAIL A
SCALE 2X
C2-2
D7-2
C2-3
D7-3
C2-4
D7-4
C2-5
D6-5

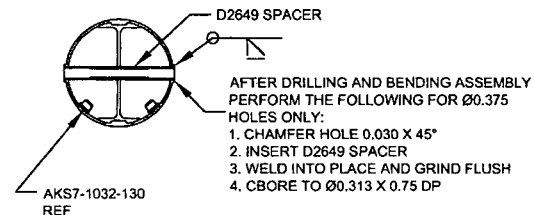
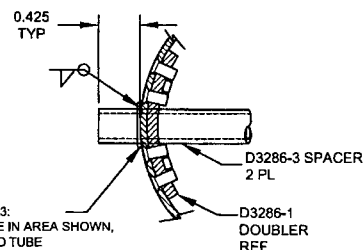


DETAIL B
SCALE 2X
C3-2
C3-3

- TO INSTALL D3286-1/3:
1. GRIND OFF FLANGE IN AREA SHOWN, FLUSH WITH ROUND TUBE
 2. LOCATE & DRILL D3286-1 DOUBLER USING DT3286-1T1
 3. ENLARGE HOLES IN D3286-1 TO Ø0.500
 4. ENLARGE HOLES IN TUBE TO Ø0.625 AND CHAMFER HOLE 0.030x45°
 5. RIVET D3286-1 TO TUBE
 6. INSERT D3286-3 SPACER
 7. WELD IN PLACE.

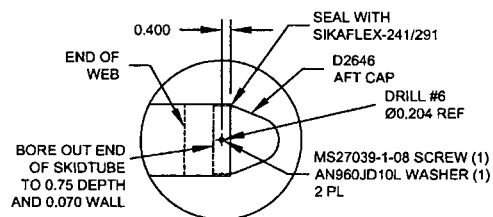


SECTION C-C C7-6
SCALE NONE

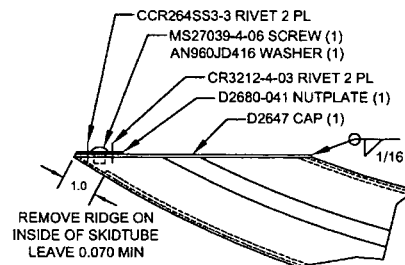
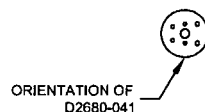


DETAIL D
FOR Ø0.375 HOLES ONLY
SCALE 3X
B4-2
B4-3
B4-4
B4-5

w/c 610414



DETAIL E
SCALE 2X
B2-2
B2-3
B1-4
B1-5







DETAIL F
SCALE NONE
B8-2
B8-3
B8-4
B8-5

DETAIL F NOTES:

1. CUT TUBE LEVEL
2. REMOVE RIDGE ON FWD SIDE
3. LOCATE D2647 (TRIM AS NECESSARY)
4. WELD D2647 IN PLACE PER DART QSI 004
5. GRIND FLUSH
6. RIVET D2680-041 NUT PLATE IN PLACE

NOTE: MASK THREADS IN D2680-041 PRIOR TO FINISH

RELEASED
08-09-22-198

DESIGN	DS	DART AEROSPACE USA, INC	
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NO. 235

AWS D17.1.2001
QUALIFICATION TEST RECORD

Name: Berday Elliott
Job number: 59780
Part number: D206-642-541
Description: 206 skid tube
Welding Process: Tig~~T~~ Mig~~[]~~
Base material: Aluminium
Current: AC~~[]~~ DC~~[]~~

TEST REQUIREMENTS AND RESULTS

Visual:
Penetration:

pass~~[]~~ fail~~[]~~
pass~~[]~~ fail~~[]~~

UNACCEPTABLE

Cracks:
Undercut:
Pin holes:
Overlap (cold lap)
Porosity (surface):
Coloration:

pass~~[]~~ fail~~[]~~
pass~~[]~~ fail~~[]~~
pass~~[]~~ fail~~[]~~
pass~~[]~~ fail~~[]~~
pass~~[]~~ fail~~[]~~
pass~~[]~~ fail~~[]~~

Qualifier P. A. W.

Date of Test Coupon 10.07.01

Welder Berday Elliott

Date of Test Coupon 10.07.01

The above named individual is qualified in accordance with AWS D17.1.2001 to weld